

Work Order ID 68340

Tuesday, April 12, 2011 10:05:51 AM



Page 1

Item ID: D3278-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 4/12/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 4/04/12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3278	Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3278 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

NOT PULLED

B11-4-12

Ep 4/04/12 (110)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-4-12

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8,104/110

*counted
(+110)*

QSP015

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68340

Tuesday, April 12, 2011 10:05:52 AM



Page 2

Item ID: D3278-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 4/12/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-C'sink as per dwg D3278-2-Deburr

Handwritten signature and date: 4/14/13

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Handwritten signature: S. M. 4/18

Handwritten: 16000

Handwritten: (HIC)

Handwritten: QSP015

150

0.00



Identify as per dwg & Stock Location: *6-A*

Packaging

Memo

0.00

Packaging

Handwritten signature and date: 4/18/13 (HIC)

W/O:		WORK ORDER CHANGES					
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Page 3

Tuesday, April 12, 2011 10:05:52 AM

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Revision ID:					Stop	
Item Name:	Spacer					
Start Date:	4/12/2011	Start Qty:	40.00		Cust Item ID:	
Required Date:	4/18/2011	Req'd Qty:	40.00		Customer:	
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/4/19
MF
11-04-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 12, 2011 10:05:58 AM

Page 1

Work Order ID: 68340

Parent Item: D3278-3

Parent Item Name: Spacer



Start Date: 4/12/2011

Required Date: 4/18/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A 04.04.19 New issue KJ/JLM
IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDELRINS0.125

Purchased

No

110

sf

0.0000

0.0344

1.448421

4.



B11-4-12

Black Delrin Sheet .125

.125" x 24" x 36"

116779

110

W/O:		WORK ORDER CHANGES					
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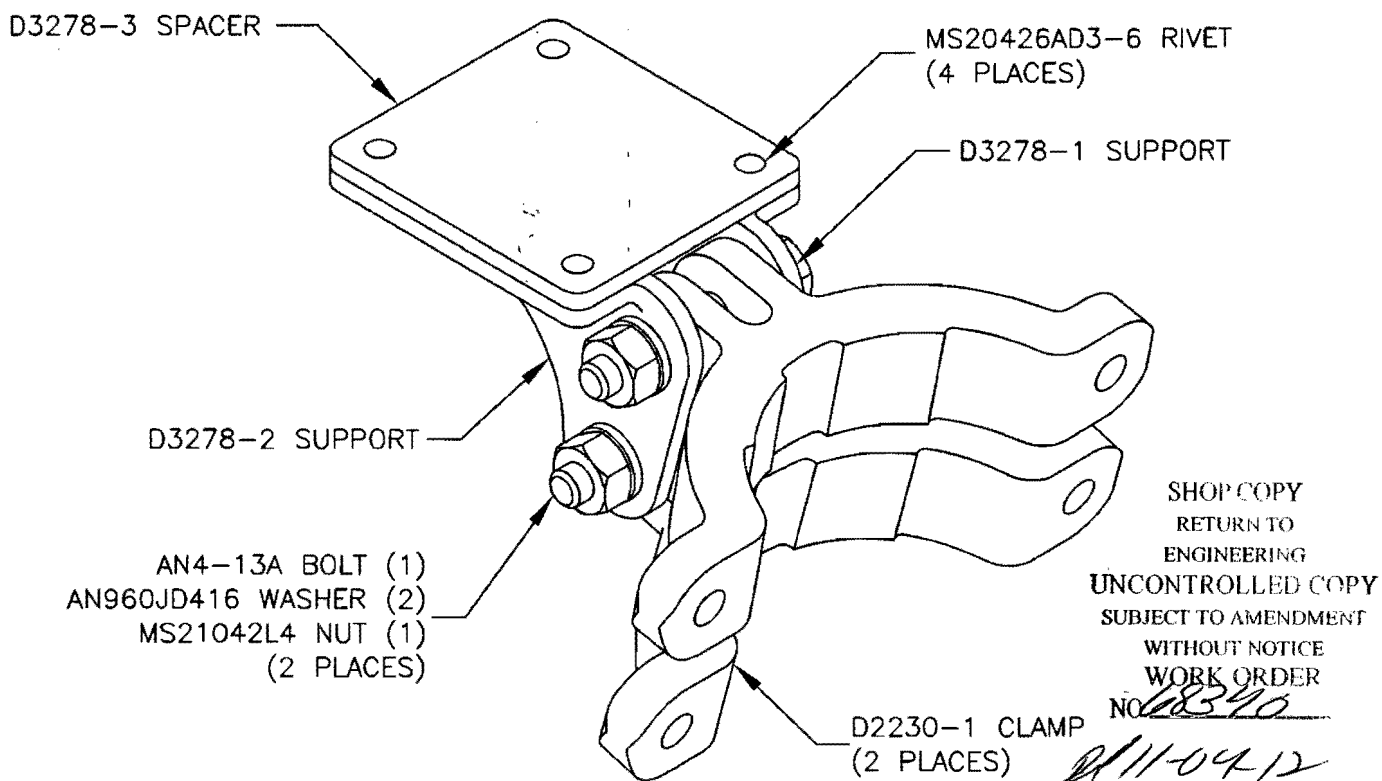
NOTE: Date & initial all entries

DART

DESIGN <i>90</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-48

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

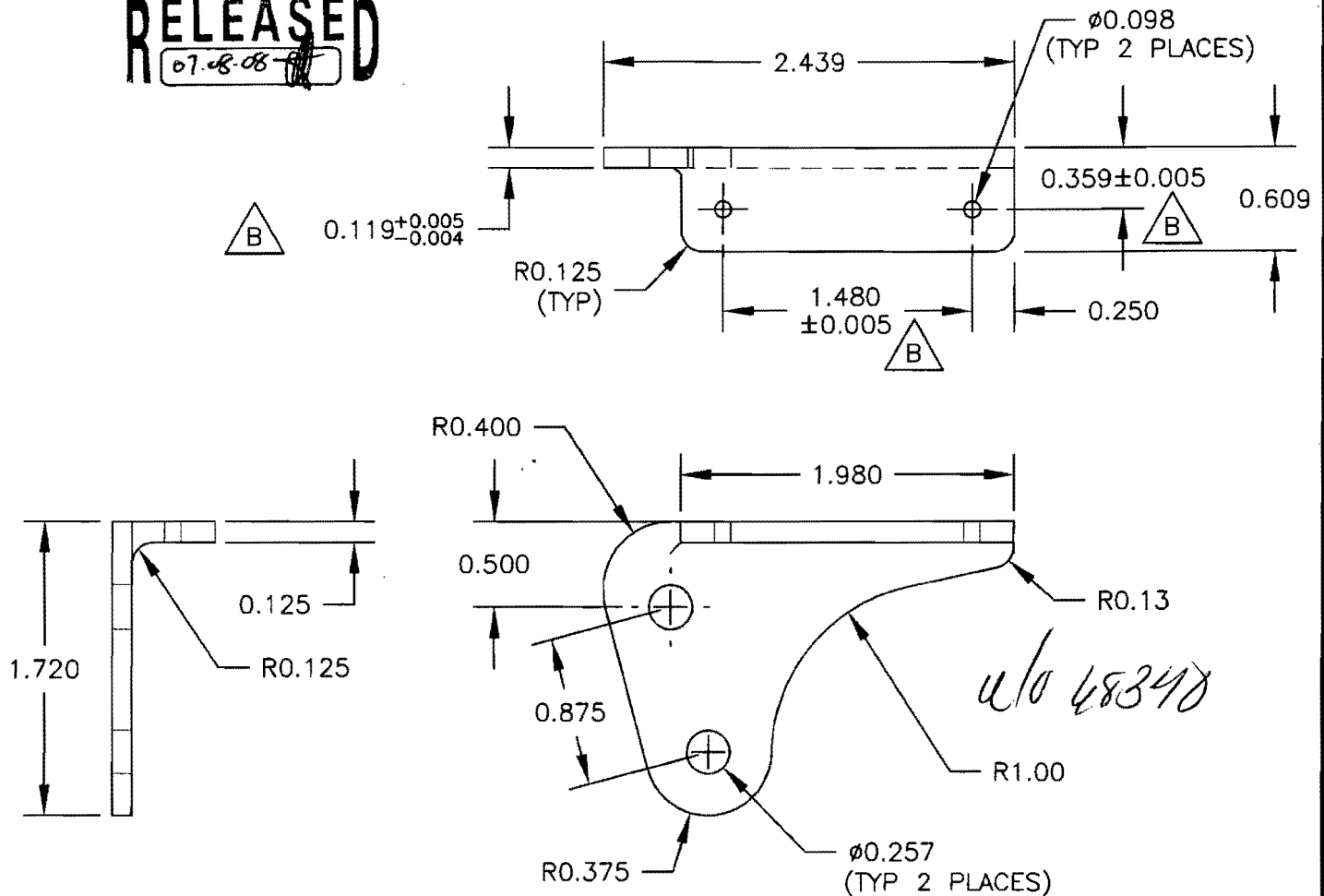
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NOTE: Date & initial all entries

DART

DESIGN <i>qp</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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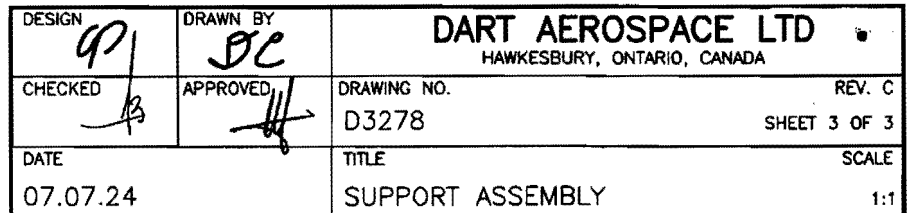
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

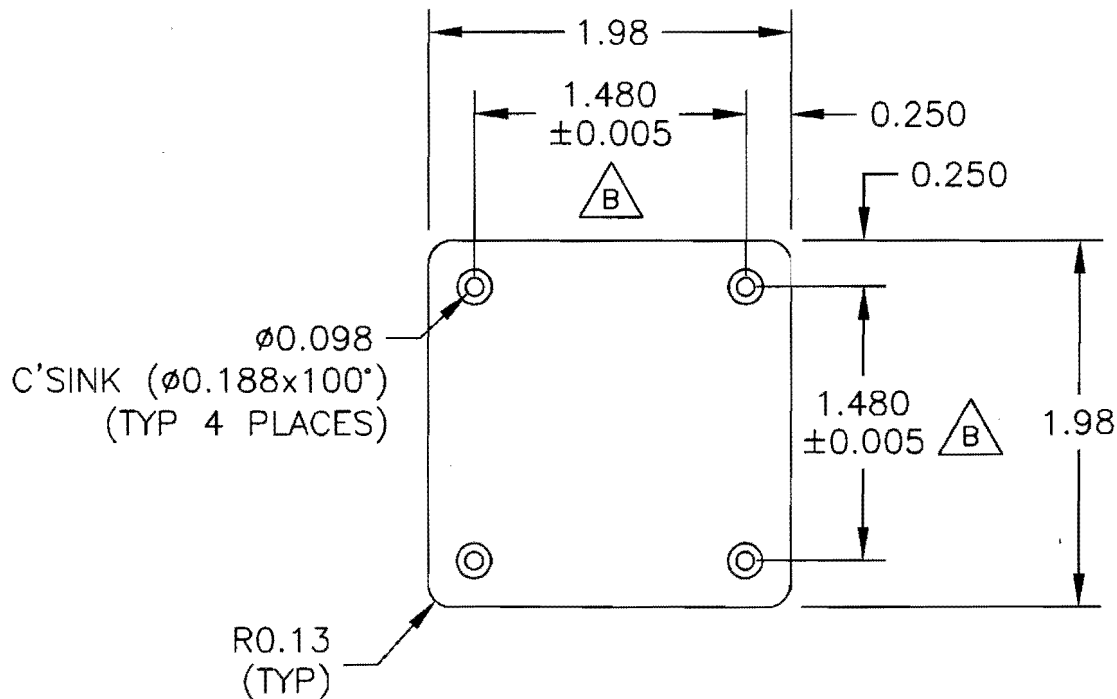
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- **NOTE:** Date & initial all entries



RELEASED
07.08.08



u/o 68348

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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